

4/30/2018

[Dart Hawkesbury] Job Sheet - David, Logan



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB T101530-11
Job Sheet 176770



Part No: RB T101530-11

Job Qty: 5 ea

Part Name: Bearing Roll Stake Roller



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/30/18

Job Tracking No:

Due Date: 4/30/18

Created By: Logan David

Type: Stock

Description:

Note: DWG T101530 Rev C IPP Rev A 18.03.05 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea		4/30/18	0.00	0.00	Start Up Machining-3		18-5-1
110	CNC Lathe	5 pcs		4/30/18	0.00	0.50	MORI SL-154		18-5-3
120	QC	5 pcs		4/30/18	0.00	0.00	QC2 Machining-4		18-5-14
130	QC	5 pcs		4/30/18	0.00	0.00	QC8 Machining-4		18-05-05
135	Outsource	5 pcs		4/30/18	0.00	0.00	Outsource1		18-05-18
140	Outsource	5 pcs		4/30/18	0.00	0.00	Outsource13		18-05-18
150	Packaging	5 pcs		4/30/18	0.00	0.00	Packaging2		18-05-18
160	QC	5 pcs		4/30/18	0.00	0.00	QC6		18-05-18
210	Packaging	5 pcs		4/30/18	0.00	0.00	Packaging3-1		18-05-18
220	QC21-SA	5 Ea		4/30/18	0.00	0.00	QC21		18-05-18

Part Op 110 - 1-Machine as per DWG. FB994 FOLIO REV: _____ DWG REV: _____ 2-Debur
 Descriptions: 135 - 1-Issue P/O to Metcote; P/O 0397916 RC 56-59 2-Bead blast 3- Certificate of Conformity is required
 NOTE DROP SHIP TO FINISHER Metcote to ship directly to Groupe Altech***
 140 - -Issue P/O to Groupe Altech: P/O 0397913 -Zinc plate, ASTM B633 TYPE 2 SC2 -Color BLACK -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-O1-R1.000	Tool Steel Round Bar 1.000 dia.	.1500 ft (.03 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-O1-R1.000	0	6	0

Part Specifications

Specifications could not be found.

Plex 4/30/18 3:21 PM dart.logan.david



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S067328



Part: RB T101530-11

Job No: 176770

Serial No/Batch: S067328

Revision: C

Inspector:

Date: 05/01/18

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	14.07.14	New Issue	KJ	

Atlantic Heat Treating (2001) Ltd

Certification

Order No.: 154797
Date: 14/05/2018
Entry Date: 11/05/2018
Page: 1 of 1

To:
DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: PO39796

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: 01

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
5	5 PCS MATERIAL 01 HARDEN TO 58-59 RC SANDBLAST C OF C PART # RB T101530-11	1

Insp. Type	Scale	Minimum	Maximum	Number	Other
Customer Requirements:					
Harden rockwell					
Results:					
Harden ROCKWt	56.	59.	59.	tested as per sampling plan	
heated 59rc harden as per cust requested					

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY) ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards will remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT. TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS, IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER. IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE AFOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of material by customer. No claim will be allowed for shrinkage, expansion, distortion, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any spoilage, inherent or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its receipt, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN UNLESS / AFTER OUR SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.


KEAN SHEPHERD
QUALITY CONTROL
ATLANTIC HEAT TREATING 2001 LTD



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039893**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO039893
PO Date: 5/14/18
Due Date: 5/16/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	173856	RBE350A93-3303-02-1	Receiver Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	5/16/18	10 pcs	0 pcs ✓ 10x	10 pcs	\$5.41/pcs	\$54.10
2	173891	RBE350A93-3303-02-3	Extractor Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	5/16/18	10 pcs	0 pcs ✓ 10x	10 pcs	\$2.65/pcs	\$26.50
3	175521	RBT18635-5	Rod -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	5/16/18	5 pcs	0 pcs ✓ 5x	5 pcs	\$2.05/pcs	\$10.25
4	175524	RBT18635-9	Spud -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	5/16/18	5 pcs	0 pcs ✓ 5x	5 pcs	\$2.40/pcs	\$12.00

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	173776	RB T101530-11	Bearing Roll Stake Roller -Issue P/O to Groupe Altech: P/O -Zinc plate, ASTM B633 TYPE 2 SC2 -Color BLACK -Certificate of Conformity is required	Firmed	5/16/18	5 pcs	0 pcs	5 pcs	\$15.00/pcs	\$75.00
	176770			Firmed	5/16/18	5 pcs	50 pcs	5 pcs	\$15.00/pcs	\$75.00
Sub Total:						10	0	10		\$150.00
6	170761	RB AN8514-1-5	3-Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	5/16/18	3 pcs	0 pcs	3 pcs	\$2.00/pcs	\$6.00
7	171227	C45-15-6	Bushing, Lifting ISSUE P/O TO GROUPE ALTECH: QQ-N-290, CLASS 2 GRADE E OR F. NICKEL PLATE TO .0004-.0006 C OF C IS REQUIRED	Firmed	5/16/18	10 pcs	0 pcs	10 pcs	\$12.00/pcs	\$120.00
8	175845	RB AN8515-1-7	3-Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	5/16/18	4 pcs	0 pcs	4 pcs	\$2.00/pcs	\$8.00
9	175816	RB AN8515-1-5	3-Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	5/16/18	4 pcs	0 pcs	4 pcs	\$2.50/pcs	\$10.00
10	170759	RB AN8514-1-4	3-Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	5/16/18	3 pcs	0 pcs	3 pcs	\$1.80/pcs	\$5.40



Certificat de Conformité / Certificate of Compliance

(009320-2)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

009320 - 2

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
17-May-2018		Aman		039893					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
5	RBT101530-11 Rev.	RBT101530-11 01 -ZINC BLACK [ZINC BLACK] ASTM B633 TYPE 2 SC2	ZINC CH	10	10	0	0	0	
7	C45-15-6 Rev.	C45-15-6 01 -E-NIC STEEL 500 [E-NICKEL STEEL 500] QQ-N-290 CLASS 2 GRADE E OR F NICKEL PLATE TO 0.0004-0.0006 THICK	E-NICKEL STEEL CH	10	10	0	0	0	
14	SWA3-300 Rev.	SWA3-300 01 -ANO-BLACK [ANODIZE BLACK] MIL-A-8625F TYPE 3 CLASS 2	ANODIZE CH	10	10	0	0	0	

Notes Additionnelles / Additional Notes

50x / 2 8135

Épaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been processed in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.